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D4131-043
Job Sheet 183961



Part No: D4131-043

Job Qty: 4 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 10/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C SHEETS 2,9 IPP Rev:A 10.10.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	4 pcs		10/12/18	0.00	0.45	Waterjet 1		SC 18/10/18 DAS
120	QC	4 pcs		10/12/18	0.00	0.00	QC8		OCT 15 2018 68
130	Small Fab	4 pcs		10/12/18	0.00	0.25	Small Fab-6		DAS 68
150	QC	4 pcs		10/12/18	0.00	0.00	QC5		OCT 15 2018 68
160	HandFinish	4 pcs		10/12/18	0.00	0.23	HandFinish1		D.R. 18/10/18 69
161	QC	4 pcs		10/12/18	0.00	0.00	QC7-3		DAS 38
165	Small Fab	4 pcs		10/12/18	0.00	0.25	Small Fab-6		DAS 38
166	QC	4 pcs		10/12/18	0.00	0.00	QC5		DAS 38
180	Packaging	4 pcs		10/12/18	0.00	0.00	Packaging3-2	56079 6	OCT 19 2018 9-89
190	QC21-SA	4 Ea		10/12/18	0.00	0.00	QC21	3-80 DAS	OCT 19 2018 9-89

Part Op 100 - 1-Cut D4131-7 as per Dwg Dwg Rev: C Prog Rev: C 2-Debur as required 21 OCT 19 2018
 Descriptions: 130 - COUNTER SINK AS PER DWG Debur if necessary.
 165 - ASSEMBLE NUT PLATES AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.7228 sf (.1807 ea)	100-Waterjet	5018002
MS20426AD3-3	Rivet	32 Ea (8 ea)	165-Small Fab	5018535
MS21069L3	Anchor Nut	16 Ea (4 ea)	165-Small Fab	5050044

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.063	1	206	0
165-Small Fab	MS20426AD3-3	32	3,533	0
	MS21069L3	16	146	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	9,100	Diameter
2	Doubler Assembly	0.191Inches + 0.005 - 0.001	0.196 0.190	9,192	Diameter
3	Doubler Assembly	0.250Inches ± 0.010	0.260 0.240	9,252	
4	Doubler Assembly	0.500Inches ± 0.010	0.510 0.490	9,505	
5	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	9,409	
6	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	9,408	
7	Doubler Assembly	0.590Inches ± 0.030	0.620 0.560	9,591	
8	Doubler Assembly	0.660Inches ± 0.030	0.690 0.630	9,666	
9	Doubler Assembly	3.640Inches ± 0.030	3.670 3.610	3,644	
10				4,004	
11				4,103	
12				4,812	
13				4,600	
14				5,414	
15				9,060	

10/1/18 10:09 AM Dart.Gagnon.Michelle

DART
 AEROSPACE
 Container No: S118089
 Part: D4131 - 043
 Job No: 183961
 Serial No/Batch: S118089
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various ST's
 Date: 10/14/18
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